



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

ASAP

5008472

D4857-041

Job Sheet 168010



PER NCR 17-6591

Part No: D4857-041

Job Qty: 3 ea

Part Name: Wiper Deflector Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/9/17

Job Tracking No:

Due Date: 11/10/17

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Leonardo S.p.a (CAGUS03)

Piazza Monte Grappa 4 Rome, RM, 00195 Italy ph:39 0331 229294 fx:+39 0331 229730.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	11/9/17	11/9/17	0.00	0.00	Start up container		MCC
110	Small Fab	3 pcs	11/9/17	11/9/17	0.00	1.57	Small Fab		MCC
120	QC	3 pcs	11/9/17	11/9/17	0.00	0.00	QC5		17/11/10
130	HandFinish	3 pcs	11/9/17	11/9/17	0.00	0.28	HandFinish6		
140	QC	3 pcs	11/9/17	11/9/17	0.00	0.00	QC14		
150	Small Fab	3 pcs	11/10/17	11/10/17	0.00	1.57	Small Fab		
160	QC	3 pcs	11/10/17	11/10/17	0.00	0.00	QC5		
170	Packaging	3 pcs	11/10/17	11/10/17	0.00	0.00	Packaging3		
180	QC21-SA	3 Ea	11/10/17	11/10/17	0.00	0.00	QC21		5/17/11/15

Part Op 110 - Drill holes for D4857-1 as per dwg using DT10028

Descriptions: 130 - Touch up holes with primer as per dwg A/R PRIMER BATCH: N/A

150 - BOND GASKET AS PER DWG USING DOW CORNING 736 ADHESIVE BATCH: M130977

* Manufacture to Production Permit # 6000033312

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4857-M CCR 136A	3	16	0	0
150-Small Fab	D4944-1	6	17	0	0

Part Specifications

Specifications could not be found.

Plex 11/9/17 12:40 PM dart.lacelle.linda

DART
AEROSPACE
S008472

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Wiper Deflector Assembly

PART NO: D4857 - 041

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 11/09/17

Job No: 168010

Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

ORDER ACKNOWLEDGEMENT

CUSTOMER

Customer Code: CAGUS03
Sold To: Leonardo S.p.A
Piazza Monte Grappa 4
00195 Rome
Italy
Phone: 39 0331 2292068
Fax: +39 0331 229730
Ship To: Leonardo Helic. - Vergiate
Via Roma 51
21029 Vergiate
Italy

ORDER

Order No : 1072
Date: 11/7/17
Ship-To Contact: Antonella Diluca
Email: antonella.diluca@leonardocompany.com
Cust PO No: PO4801637785/Case10002
FOB: Shipping Point
Ship Via: FedEx Intl Priority
Freight Terms: PrePaid
Terms: Net 30
INCO Terms: DDP - Delivered Duty Paid
Order Taker: Lisa McMachen
Order Taker Phone: 613-632-5200
Order Taker Email: lmcachen@dartaero.com

ORDER NOTES

Line	No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price
1		11/9/17	11/9/17	D4857-041	Wiper Deflector Assembly	3	pcs	\$1,990.00	USD	\$5,970.00
					100% Discount Warranty			-100.00		\$-5,970.00
										\$0.00 USD
										\$0.00 USD
										Grand Total

PRODUCTION PERMIT MUST BE SIGNED OFF BEFORE WE SHIP - SEE ERIC D. ADD THE PRODUCTION PERMIT TO THE BOX NO HOLES TO BE ADDED TO THE D4857-1, INCLUDE GASKETS SEPERATELY*** SHIP BEFORE IF POSSIBLE*** Anomaly Report: QJ 200001282441 & QJ 200001283248. NCR17-6591. Ship via Dart Fed-Ex 1517-9324-0.
Remit to: DART Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario K6A 1K7 Canada
Tel: 613 632 5200 Fax: 613 632 5246 accounting@dartaero.com
GST/HST 10127 2607
Note: A minimum 15% restocking fee is applicable. Custom items are non-refundable. Full warranty details are available at www.dartaerospace.com

Plex 11/8/17 10:20 AM Dart.McMachen.Lisa

Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Friday, November 10, 2017

Details			
Raised Date 8/30/2017	Status Open	Owner Menard, Jean-Luc	Number NCR17-6591
Target Date 11/24/2017	Standard ISO 9001:2008 / AS9100\7.0 Product Realization\7.5 Product And Service Provision\7.5.2 Validation of processes for production and service provision		Severity MAJOR
Process Customer Complaint		Audit	
Raised By Person FINMECCANICA / AGUSTAWESTLAND	Raised Against (Department or Supplier) Manufacturing		Fault Category Other\Non-compliance to specified requirements
Details Was reported by Leonardo Italy on Anomaly Report #QJ200001245642 that hole pattern on D4857-041 (B157892 x2) from 6F6540V00131 B157890 sent out on SO129807 is not correct. SO131364 affected also (6F9540V00131, B164471): Anomaly Report: QJ 200001282441 & QJ 200001283248 issued by Leonardo against SO131364.			
Keywords		Product D4857-041	
Document		Root Cause Insufficient Tooling	
Closed By	Closed Date	Resolution Process Improvement	

Root Cause			
Target Date 9/8/2017	Owner Downing, Eric M	Closed Date 9/1/2017	Closed By Downing, Eric M
Details Dart tooling was not correctly verified at original tool approval.			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	9/1/2017	8/30/2017
Review issue and perform a root cause investigation.		Performed the following: Used DT10028 to drill into blank aluminium plate to review verify hole placement. Found that hole placement is inverted and does not correspond to drawing dimensions.	

Corrective Action

Target Date 11/24/2017	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	
2	Duval, David	11/8/2017	9/21/2017
Create proper checking tool to prevent parts with incorrect hole placement being shipped to Leonardo		made template DT10341	
3	Duval, David	11/8/2017	9/21/2017
Create new Drill Jig to prevent from reoccurring		Revise drill jig, DT10028 rev.b	
4	Duval, Patrick	11/8/2017	11/10/2017
Perform Complete FAI inspection & document it on next production parts to ensure parts match drawing requirements		Parts match drawing but due to discrepancy reported by Leonardo issue with 2d drawing to 3d model.	
5	Duval, Patrick	11/8/2017	
Pull all D4857-041 & D4857-1 parts from stock and record on quarantine item sheet			
7	Monterroza, William	11/8/2017	
Put D4857-041 U/R until we receive updated drawings from Leonardo. Leonardo production permit is allowing us to ship out for now though Leonardo must approve these parts to be mfg. without holes before we ship.			
8	Downing, Eric M	11/9/2017	
Obtain new hole dimension drawing from Leonardo.			
11	Lavoie, Chantal	11/10/2017	
Order more D4857-M to ensure we have enough stock based on current orders in the system.			
9	Monterroza, William	11/17/2017	
Engineering to update the 2-d drawing based on the new dimensions received from Leonardo.			
10	Crooks, Caitlin	11/9/2017	
Put any open sales orders on hold until product is removed from U/R. Notify Leonardo that these orders are on hold.			
12	Downing, Eric M	11/24/2017	
Manufacture parts to satisfy Leonardo Helicopters with out holes per approved production permit			

Implementing Corrective Action

Target Date 11/24/2017	Owner Monterroza, William	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	
6	Monterroza, William	11/24/2017	
Implement actions to ensure no recurrence of issue happens on other products			

Verification & Review

Target Date 11/24/2017	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

	DEVIAZIONE (Deviation / Production Permit)		PP n. 6000033312	
			PAG. 1 / 2	
Stabilimento emittente IT13 Leonardo Helic. - Vergiate			Data 14.11.2017	
Ragione sociale e indirizzo Subfornitore DART AEROSPACE LTD ABERDEEN STREET - K6A 1K7 - HAWKESBURY - ON				
Linea Prodotto 30 - Vendors			Contratto 4801637785	
P/N D4857-041	Esp.disegno N/A	Descrizione DEFLECTOR, WIPER LH ASSY		
Criticità NC	Quantità 3,000	Partita		
S/N		NC Elicottero		
RICHIESTA DI DEVIAZIONE				
Descrizione della deviazione 0001 - D004 - SEMILAVORATO * 14.11.2017 17:38:15 GUIDO BRUSCINO (40067) * see supplier document attached				
Motivo della deviazione C004 AVANZAMENTO				
Azioni correttive N.A				
Effetti sui costi ☐ SI ☒ NO		Effetti sul programma ☐ SI ☒ NO		Effetti sui tempi di consegna
Compilatore GUIDO BRUSCINO		Funzione Supplier & Incoming Parts Quality		Data 14.11.2017

	DEVIAZIONE (Deviation / Production Permit)		PP n. 6000033312													
			PAG. 2 / 2													
VALUTAZIONI DELL'ENGINEERING																
Valutazioni dell'engineering * 15.11.2017 10:10:35 MARCELLO STEFANELLI (9273) * The deviation is acceptable, this has not effect on the functionality of the parts.																
Rapporto di indagine																
Caratteristiche inficiate dalla deviazione <table border="0"> <tr> <td>☐ Sicurezza</td> <td>☐ Intercambiabilità</td> <td>☐ Testabilità</td> </tr> <tr> <td>☐ Vita</td> <td>☐ Affidabilità</td> <td>☐ Altri / Aspetto</td> </tr> <tr> <td>☐ Resistenza</td> <td>☐ Manutenibilità</td> <td>☒ Nessun effetto</td> </tr> <tr> <td>☐ Prestazioni</td> <td>☐ Installabilità</td> <td></td> </tr> </table>					☐ Sicurezza	☐ Intercambiabilità	☐ Testabilità	☐ Vita	☐ Affidabilità	☐ Altri / Aspetto	☐ Resistenza	☐ Manutenibilità	☒ Nessun effetto	☐ Prestazioni	☐ Installabilità	
☐ Sicurezza	☐ Intercambiabilità	☐ Testabilità														
☐ Vita	☐ Affidabilità	☐ Altri / Aspetto														
☐ Resistenza	☐ Manutenibilità	☒ Nessun effetto														
☐ Prestazioni	☐ Installabilità															
Classificazione ☐ Maggiore ☒ Minore																
Marcatura ☐ SI ☒ NO																
Limitazioni ☐ SI ☒ NO																
Firma ATE MARCELLO STEFANELLI			Data 15.11.2017													
APPROVAZIONI																
Approvazione La richiesta di scostamento dai requisiti definiti nei Dati di progetto applicabili é : ☒ APPROVATA ☐ NON APPROVATA																
Commento Approvazione (ATE/CPE)																
ATE MARCELLO STEFANELLI	CPE	Ingegneria/Qualità GUIDO BRUSCINO	Coordinatore Qualità GUIDO BRUSCINO	UTT / Rappresentante del Cliente												
Data 15.11.2017	Data	Data 15.11.2017	Data 15.11.2017	Data												

 AgustaWestland A Finmeccanica Company		DEVIATION PERMIT					Pag. 1 of 1									
Manuf. Doc. N.	21000667	Date	2017/11/08	AW Doc. N.	N/A	Purchase Order	4801637785									
AW P/N	D4857-041	S/N / Batch Number	TBD	Grade	NC	AW Drawing Issue	6F9540V0131 Rev C									
Description	Upper Cutter Assembly "Wiper Deflector"			Batch Q.ty	3	Defective Q.ty	3									
Manufacturer	Dart Aerospace Ltd			Model	AW169											
Deviation(s) Description																
D4857-041 (-1) ,P/N 6F9540V0131, to be supplied with out the 4x Ø5.33mm / Ø.210" holes drilled per drawing. The operation of drilling the 4x Ø5.33mm / Ø.210" holes to be performed leonardo operators.																
				<table border="1"> <tr> <th>Department</th> <th>Inspector</th> <th>Signature</th> <th>Date</th> </tr> <tr> <td>QA</td> <td>ED</td> <td>16 9-89 S</td> <td>2017/11/08</td> </tr> </table>					Department	Inspector	Signature	Date	QA	ED	16 9-89 S	2017/11/08
Department	Inspector	Signature	Date													
QA	ED	16 9-89 S	2017/11/08													
Deviation(s) Cause																
Due to issue regarding from QJ 200001282441 Dart Aerospace Drawing requirements and requirements specified in Leonardo's 3d model parts are to be supplied to Leonardo with out the Ø5.33mm / Ø.210" holes drilled per drawing D4857-041 (-1). Previous parts provided the hole pattern do not match the H/C structure																
				<table border="1"> <tr> <th>Department</th> <th>Inspector</th> <th>Signature</th> <th>Date</th> </tr> <tr> <td>QA</td> <td>ED</td> <td>DAS 16 9-89 S</td> <td>2017/11/08</td> </tr> </table>					Department	Inspector	Signature	Date	QA	ED	DAS 16 9-89 S	2017/11/08
Department	Inspector	Signature	Date													
QA	ED	DAS 16 9-89 S	2017/11/08													
Effect on costs	Zero		Effect on programme	Zero		Effect on delivery	Zero									